

Work Order ID 73852

Friday, September 16, 2011 12:49:39 PM



Page 1

Item ID: D2662-2

Accept



Setup Start



Revision ID:

Item Name: Saddle, RH In 206

Stop



Start Date: 9/16/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 10/28/2011 Req'd Qty: 10.00



Customer:

Reference:

[Signature]

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2662

Rev D

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number. ☐ Inspect part number and batch number are programmed correctly. ☐ Fixturing Inspection last completed 11.11.2 by RR ☐ Machine Step No 1 of Folio and inspect per attached Dimension Sheet ☐ Machine Step No 2 of Folio

RR 11.11.2

10

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

RR 11.11.2
SL

10

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

RR 11.11.2
SL

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Start Date: 9/16/2011 Start Qty: 10.00



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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

conf 11/11/03



QC

Memo

0.00

10

0

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

10 BL 11-11-3.

Hand Finishing

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

3:30

3200F

4:00

W 118439

10x10m-f 11/14/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73852

Friday, September 16, 2011 12:49:39 PM



Page 3

Item ID: D2662-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, RH In 206

Start Date: 9/16/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 10/28/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10 counted 11/16/11

170

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

11/16/11 9:51 100

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/16/11 10:00

MF 11-11-09

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, September 16, 2011 12:49:37 PM

Page 1

Work Order ID: 73852

Parent Item: D2662-2

Parent Item Name: Saddle, RH In 206



Start Date: 9/16/2011

Required Date: 10/28/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: C00.11.01 Removed P/O for Powder Coat - in house process EC
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001 		Manufactured	No			100	Each	49.0000	1	10			
Saddle Billet													

20 11.11.2

Location	Loc Qty	Loc Code
MAT040	49	
64777	20	
66965	1	
69677	2	
70976	10	
72225	16	

73779

X10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 73852
Description: 206 Saddle, Inboard, Right side	Part Number: D2662-2
Inspection Dwg: D2662 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.126	.126	.126	.126	.126	
B	0.100	0.140		.135	.135	.135	.135	.135	
C	1.125	1.145		1.140	1.140	1.140	1.140	1.140	
D	0.615	0.685		.685	.685	.685	.685	.685	
E	0.240	0.260		.249	.249	.249	.249	.249	
F	1.313	1.343		1.327	1.327	1.327	1.327	1.327	
G	0.210	0.230		.222	.222	.222	.222	.222	
H	0.100	0.180		.130	.130	.130	.130	.130	
I	2.470	2.510		2.491	2.491	2.491	2.491	2.491	
J	1.565	1.585		1.580	1.580	1.580	1.580	1.580	
K	0.235	0.240		.239	.239	.239	.239	.239	
L	0.100	0.120		.112	.112	.112	.112	.112	
M	0.990	1.010		1.000	1.000	1.000	1.000	1.000	
N	0.510	0.515		.512	.512	.512	.512	.512	
O	5.990	6.010		6.000	6.000	6.000	6.000	6.000	
P	1.245	1.255		1.250	1.250	1.250	1.250	1.250	
Q	2.495	2.505		2.500	2.500	2.500	2.500	2.500	
R	0.313	0.318		.314	.314	.314	.314	.314	
S	0.315	0.322		.316	.316	.316	.316	.316	
T	2.495	2.505		2.500	2.500	2.500	2.500	2.500	
U	1.357	1.367		1.362	1.362	1.362	1.362	1.362	
V	0.787	0.807		.798	.798	.798	.798	.798	
W	0.540	0.560		.549	.549	.549	.549	.549	
X	1.674	1.684		1.679	1.679	1.679	1.679	1.679	
Y	0.257	0.262		.257	.257	.257	.257	.257	
Z	0.912	0.932		.922	.922	.922	.922	.922	
AA	0.490	0.510		.502	.502	.502	.502	.502	
AB	0.178	0.198		.188	.188	.188	.188	.188	
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <i>RF</i>	Audited by: <i>RF</i>
Date: 11.11.2	Date: 11/11/03

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART AEROSPACE LTD	Work Order: 73832
Description: 206 Saddle, Inboard, Right side	Part Number: D2662-2
Inspection Dwg: D2662 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.126	.126	.126	.126	.126	
B	0.100	0.140		.135	.135	.135	.135	.135	
C	1.125	1.145		1.140	1.140	1.140	1.140	1.140	
D	0.615	0.685		.685	.685	.685	.685	.685	
E	0.240	0.260		.249	.249	.249	.249	.249	
F	1.313	1.343		1.327	1.327	1.327	1.327	1.327	
G	0.210	0.230		.222	.222	.222	.222	.222	
H	0.100	0.180		.130	.130	.130	.130	.130	
I	2.470	2.510		2.491	2.491	2.491	2.491	2.491	
J	1.565	1.585		1.580	1.580	1.580	1.580	1.580	
K	0.235	0.240		.239	.239	.239	.239	.239	
L	0.100	0.120		.112	.112	.112	.112	.112	
M	0.990	1.010		1.000	1.000	1.000	1.000	1.000	
N	0.510	0.515		.512	.512	.512	.512	.512	
O	5.990	6.010		6.000	6.000	6.000	6.000	6.000	
P	1.245	1.255		1.250	1.250	1.250	1.250	1.250	
Q	2.495	2.505		2.500	2.500	2.500	2.500	2.500	
R	0.313	0.318		.314	.314	.314	.314	.314	
S	0.315	0.322		.316	.316	.316	.316	.316	
T	2.495	2.505		2.500	2.500	2.500	2.500	2.500	
U	1.357	1.367		1.362	1.362	1.362	1.362	1.362	
V	0.787	0.807		.798	.798	.798	.798	.798	
W	0.540	0.560		.549	.549	.549	.549	.549	
X	1.674	1.684		1.679	1.679	1.679	1.679	1.679	
Y	0.257	0.262		.257	.257	.257	.257	.257	
Z	0.912	0.932		.922	.922	.922	.922	.922	
AA	0.490	0.510		.502	.502	.502	.502	.502	
AB	0.178	0.198		.188	.188	.188	.188	.188	
AC									
AD									
AE									
AF									

Accept/Reject

Measured by: <u>RP</u>
Date: <u>11.11.03</u>

Audited by: <u>cmf</u>
Date: <u>11/11/03</u>

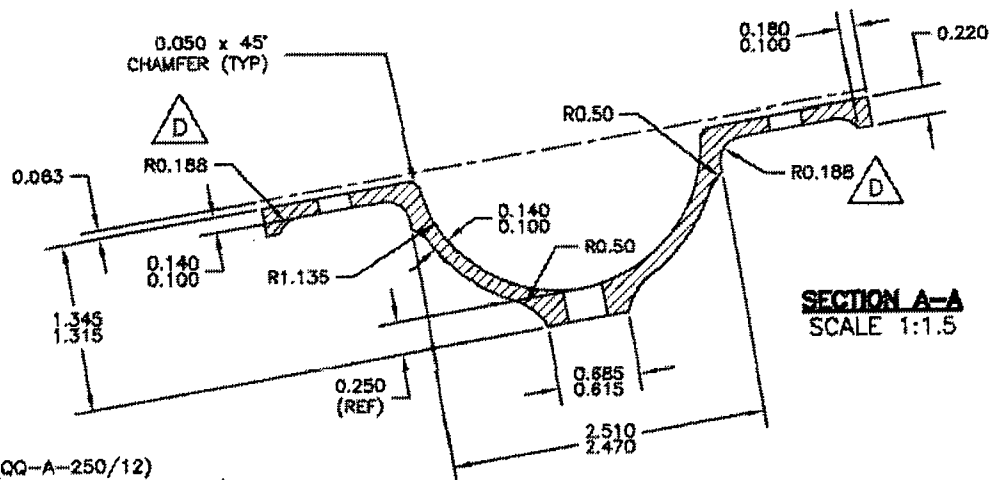
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART

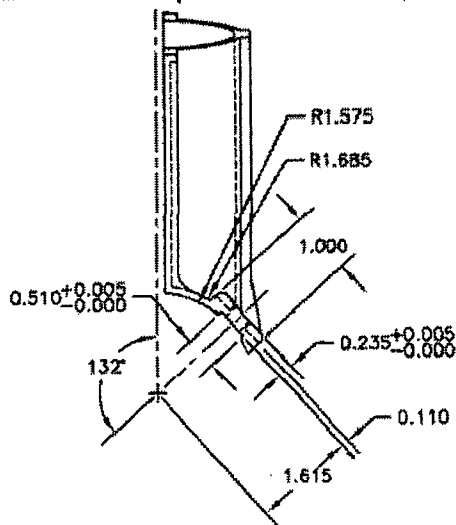
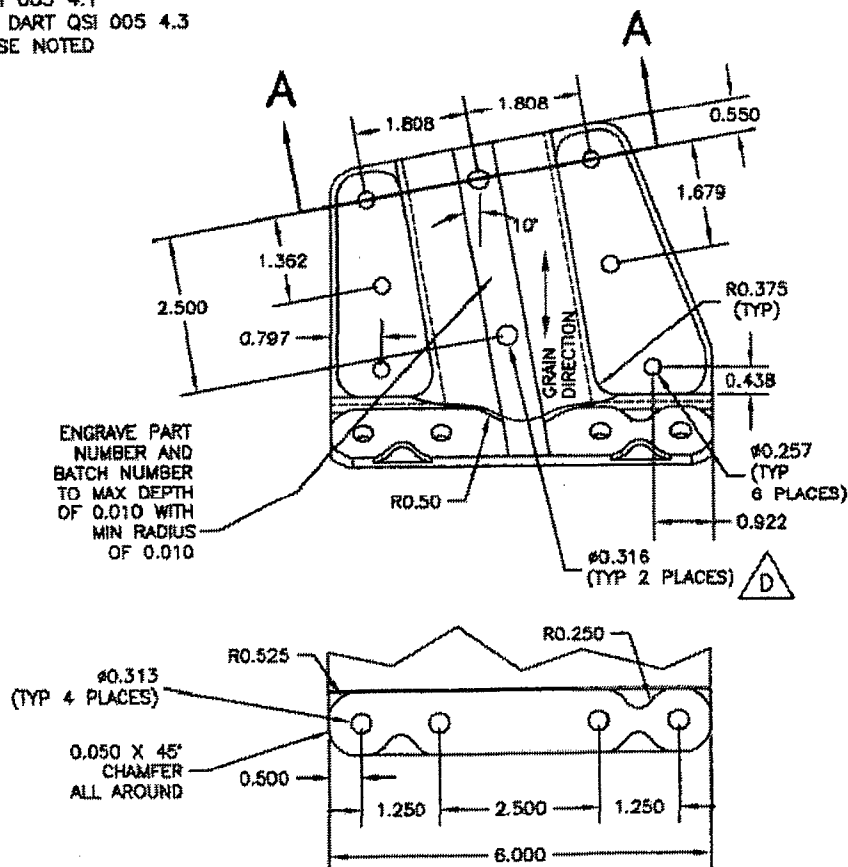
DESIGN #	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED #	DRAWING NO. D2662	REV. D SHEET 1 OF 1
DATE 06.11.08	TITLE SADDLE INSIDE		SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.29	INCORP' DEO 9122/9102/9095/9137	
D	06.11.08	RO.188 WAS RO.30; Ø0.316 WAS Ø0.313	

RELEASED

07.02.02

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) D2662-1 SHOWN (D2662-2 IS OPPOSITE)

**D2662-1 SADDLE INSIDE**

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